

Work Order ID 131226

March-31-15 8:08:26 AM

ASA Rush
131226

Page 1

Item ID: D4965-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 3/31/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4965	A

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr as required								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(4) _____ *02/15/03/31*

(9) _____ *02/15/03/31*

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/31/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/06/15 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/31/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/06/15 **Req'd Qty:** 4.00 ***4***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00

160

Memo

0.00

HandFinish

Hand Finishing

170

QC7-Inspect Chemical Conversion Coat

0.00

170

Memo

0.00

QC

Quality Control

180

Identify as per dwg & Stock Location: 0A 0.00

0.00

180

Memo

0.00

Packaging

Packaging

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Item ID: D4965-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Spacer

Start Date: 3/31/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/06/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MCS 150402

AS.42

Picklist Print

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Work Order ID: 131226

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Parent Item: D4965-7

D4965-7

Parent Item Name: Step Spacer

Start Date: 3/31/15

Required Date: 4/06/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.11.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

sf

80.5882

1

M2024T3S 040

**

02/15/03/31

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

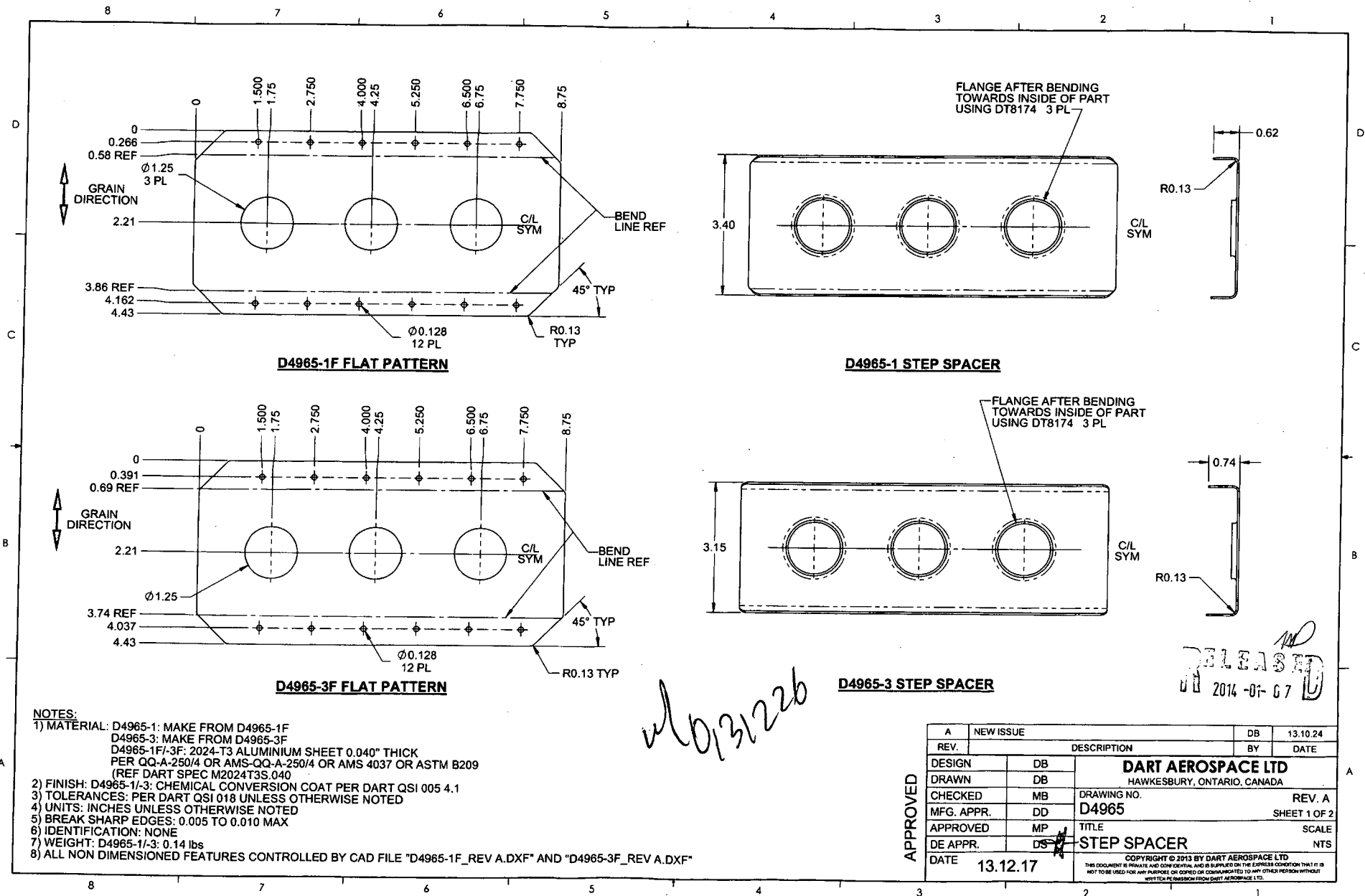
MAT022

80.5882

m130497

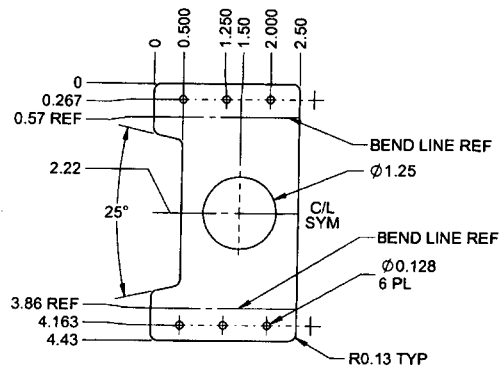
80.5882

.5



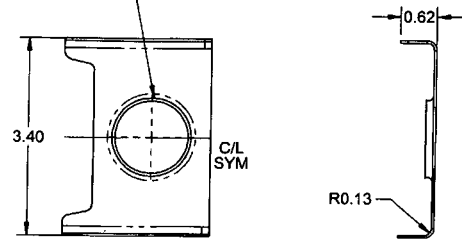
8 7 6 5 4 3 2 1

GRAIN
DIRECTION



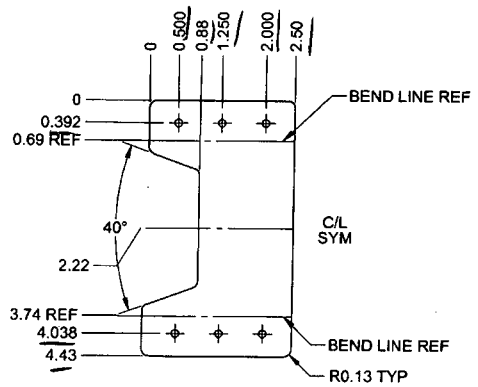
D4965-5F FLAT PATTERN

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174

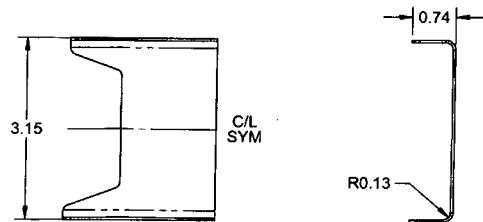


D4965-5 STEP SPACER

GRAIN
DIRECTION



D4965-7F FLAT PATTERN



D4965-7 STEP SPACER

NOTES:

- 1) MATERIAL: D4965-5: MAKE FROM D4965-5F
D4965-7: MAKE FROM D4965-7F
D4965-5F/7F: 2024-T3 ALUMINIUM SHEET 0.040" THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: D4965-5/-7: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4965-5/-7: 0.01 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4965-5F_REV A.DXF" AND "D4965-7F_REV A.DXF"

RELEASED
2014-07-07

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A
MFG. APPR.	DD	D4965	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STEP SPACER	NTS
DATE	13.12.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

